

Date: Friday, 03/04/2009 6:51:58 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 46837	
Estimate Number : 10275	
P.O. Number :	Part Number : D2565103
This Issue : 03/04/2009 S.O. No. :	Drawing Number : D2565 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 02/04/2009 Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 41893	Material :
Written By :	Due Date : 20/04/2009 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est: F02.04.16 Added dwg Rev.C1 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.5934 f(s)/Unit Total: 9.5603 f(s)

304 RD TUBE .750 X.49W

304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall

(M304TR0750W049)

Batch M111096

SB 09/04/03

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch to length as per Dwg D2565 using DT8313

SB 09/04/03

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole open to .316 Ø as per Dwg D2565 (one end only)

2-Deburr

M. 09/04/07

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/07

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

6:15

OVEN TEMPERATURE:

400°

FINISH TIME:

6:45

F 09/04/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 46837

Part Number: D2565103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BK 09-04-9 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 270

9/4/9 SO

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mf 09-04-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

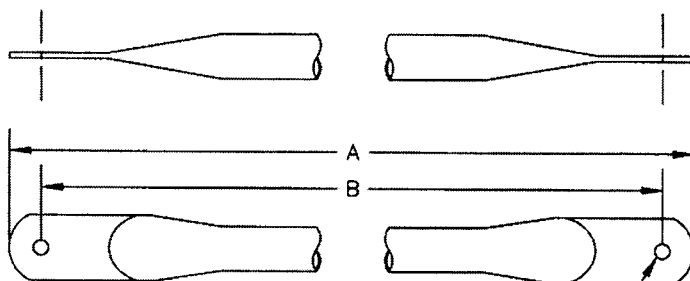
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DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT		SCALE 1:3	
A	96.05.03		NEW ISSUE		
B	97.03.15		CORRECT D2565-111 DIM. A		
C	98.10.05		UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05		ADD -3XX PARTS; ADD FINISH		
E	04.05.05		ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

w/p 46837

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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